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D4753-1

Job Sheet 188441



Part No: D4753-1

Job Qty: 48 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/9/19

Job Tracking No:

Due Date: 2/8/19

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG REV A IPP REV:A NEW ISSUE 13-02-21 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	48 pcs		2/8/19	0.00	1.44	Waterjet - Flow		SC 19/01/19
110	QC 2	48 pcs		2/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		Se 19/01/19
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

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120 HAAS 5 Axis - B4B	48 pcs	2/8/19	0.00 3.46	QC 2 - 8	
				HAAS - 5 - B4B	5x1 19-02-0
140 QC 8	48 pcs	2/8/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	5x1 19/02/02
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
150 Small Fab - 2 - B4B	48 pcs	2/8/19	0.00 0.57	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	DAS
				Small Fab - 4 - B4B	38
				Small Fab - 5 - B4B	9-89
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
160 QC 5	48 pcs	2/8/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	FEB 11 2019
				QC 5 - 9	58
				QC 5 - 50	9-89
				QC 5 - 30	
170 Handfinish - 1-1 Chemical-B4B	48 pcs	2/8/19	0.00 0.40	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/2/19

					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					2Handfinish - 1 - 22 - B4B	
180 QC 7	48 pcs	2/8/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 38	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 6	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
190 Packaging 3-1 - Stock - B4B	48 pcs	2/8/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	

DAS
 68 1902/15
 9-89

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	00
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
200 QC 21 - SA	48	2/8/19	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21 MAR 04 2019

Part Op 100 - 1-Cut as per Dwg D4753 Dwg Rev: A Prog Rev: A ***.758" DIA HOLE TO BE OPENED TO FIN
 Descriptions: SIZE BY SKID DEPARTMENT UPON INSTALLATION** 3- Debur if necessary
 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - HAAS CNC Vertical Machine - Machine as per Folio FB163 and Dwg D3506 FOLIO REV: _____ DWG
 REV: _____ ***.758" DIA HOLE TO BE OPENED TO FIN SIZE BY SKID DEPARTMENT UPON INSTALLATION**
 140 - QC8- Inspect parts - second check
 150 - C'sink as per Dwg D4753 (On Flat side)
 160 - QC5- Inspect part completeness to step on W/O
 170 - Chemical Conversion Coat per QSI005 4.1
 180 - QC7-Inspect Chemical Conversion Coat
 190 - Identify as per dwg & Stock Location: LOCATION : LG001
 200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.125	6061-T6 .125 Sheet	.6624 sf (.0138 ea)	100-Waterjet - Flow - 1	50 15009

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.125	1	55	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.128Inches + 0.005 - 0.001	0.133 0.127	0.129	Diameter
2	Doubler	0.500Inches ± 0.010	0.510 0.490	0.504	
3	Doubler	1.000Inches ± 0.010	1.010 0.990	1.003	
4	Doubler	0.750Inches ± 0.010	0.760 0.740	0.744	
5	Doubler	1.500Inches ± 0.010	1.510 1.490	1.502	
6	Doubler	2.000Inches ± 0.010	2.010 1.990	2.001	
7	Doubler	0.126Inches ± 0.010	0.136 0.116	0.123	
8	Doubler	3.540Inches + 0.012 - 0.001	3.552 3.539	3.540	Diameter
9	Doubler	0.126Inches ± 0.010	0.136 0.116	0.123	

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